

Date: Thursday, 8/23/2007 11:53:39 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 34250		
Estimate Number	: 12950		
P.O. Number	: N/A	Part Number	: D32591
This Issue	: 8/23/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3259 REV A1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 33675	Drawing Revision	: A1
		Material	: N/A
Written By	:	Due Date	: 9/15/2007
Checked & Approved By	: <u>070823</u>	Qty:	6 Um: Each
Comment	: Est Rev: A New Issue 07-07-19 JLM	Verified By:	EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 1.4574 sf(s)/Unit Total: 8.7444 sf(s)  
 2024-T3 .032 sheet  
 Batch: M102942

SAD 17/08/25

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3259  
 Dwg Rev: A1  
 Prog Rev: A1

2-Deburr if necessary ml 07/08/27(x6)

SAD 07/08/25 6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/25 6

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Er 07/08/28 (x6)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

ML 0708-31 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/08/31  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:39 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 34250

Part Number: D32591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07/18/31 (6)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57176*

*07/18/31 (6)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/18/31 (6)*

Job Completion



*07/18/31*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

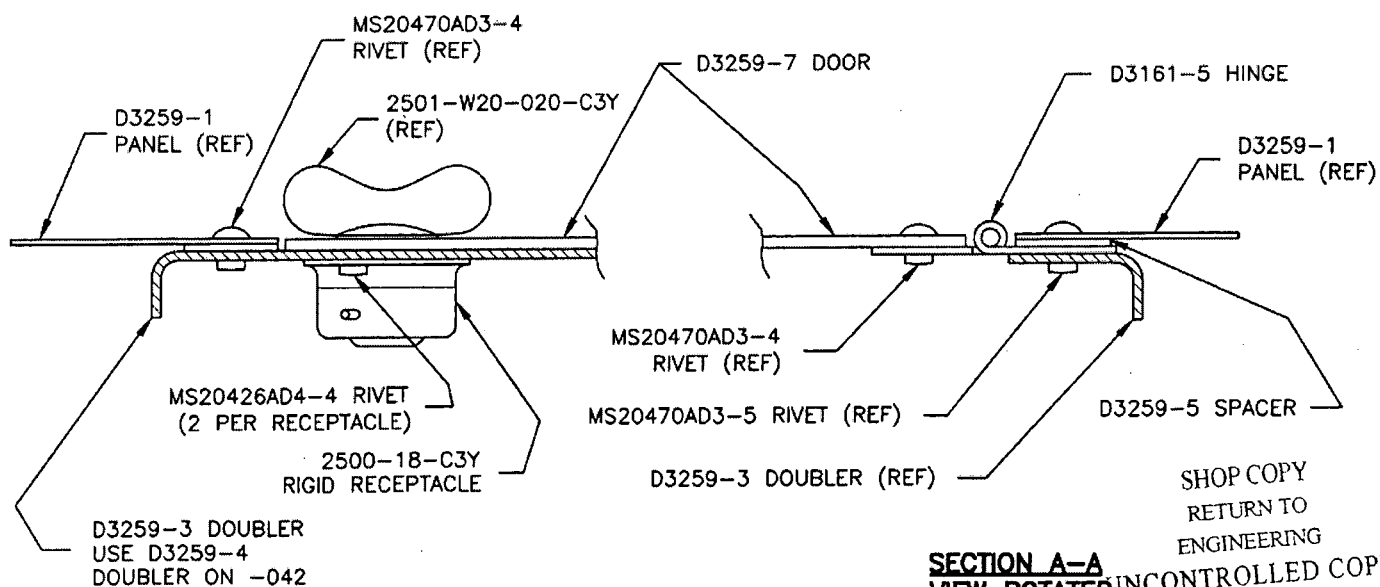
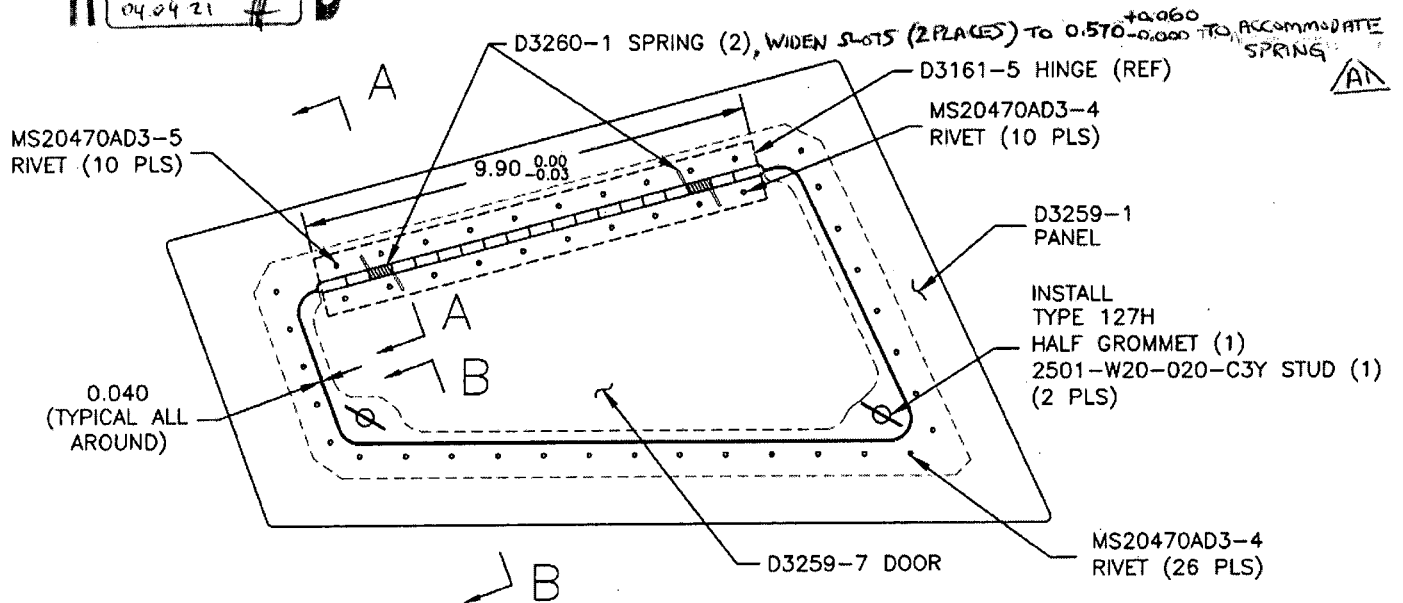
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3259
				REV. A SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE 1:4
A	04.02.25	NEW ISSUE		
A1	04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING		

RELEASED  
04.04.21



SECTION B-B  
VIEW ROTATED

SECTION A-A  
VIEW ROTATED  
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WORK ORDER  
NO. 34250

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)  
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

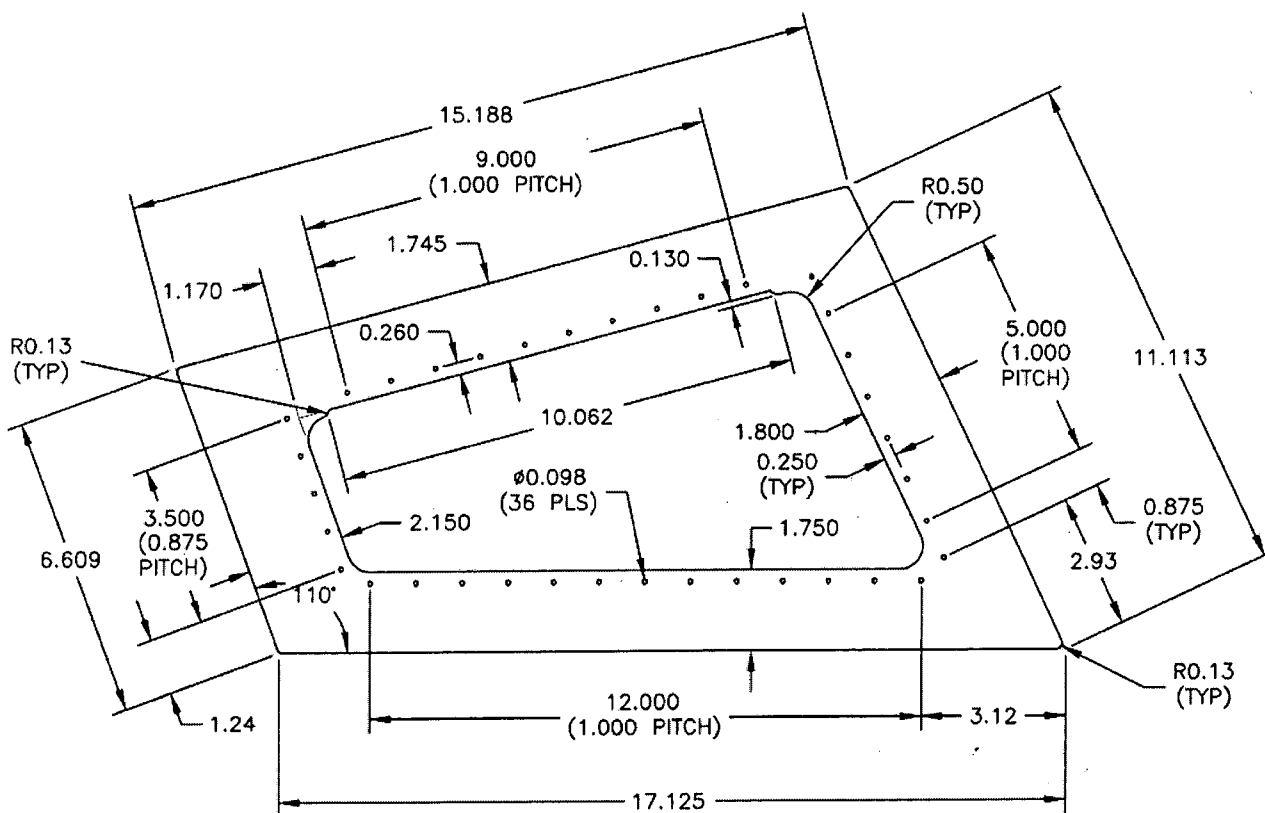
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CHECKED #	APPROVED #	DRAWING NO. D3259	REV. A SHEET 2 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.05



### D3259-1 PANEL

#### NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
NO. 34250

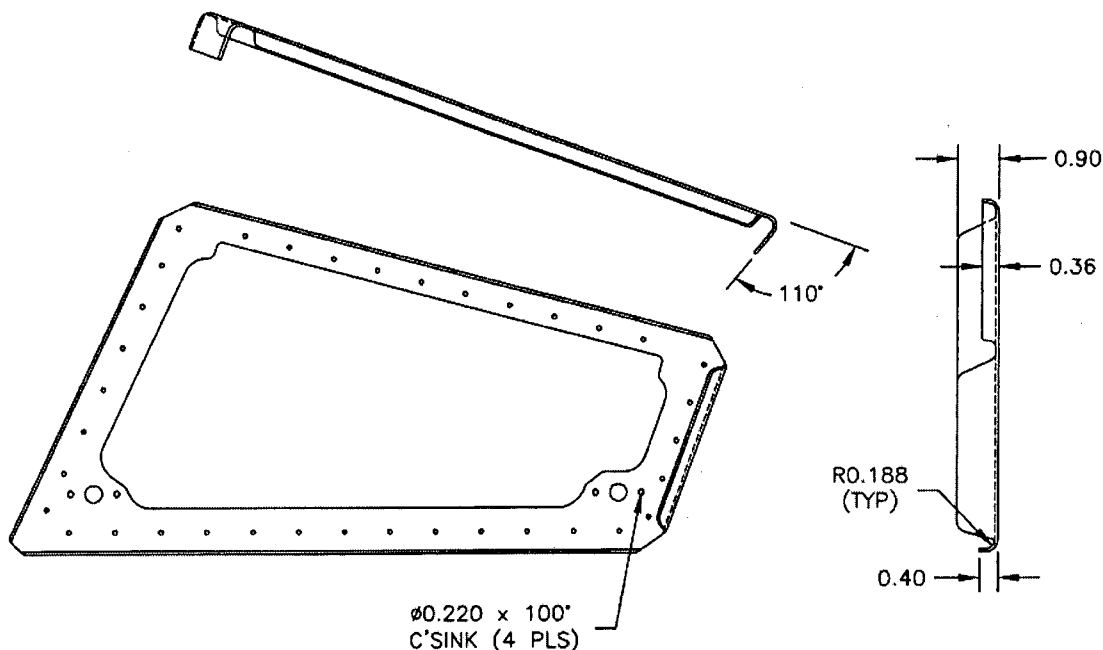
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.14 [Signature]



**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

**D3259-3/-4 NOTES:**

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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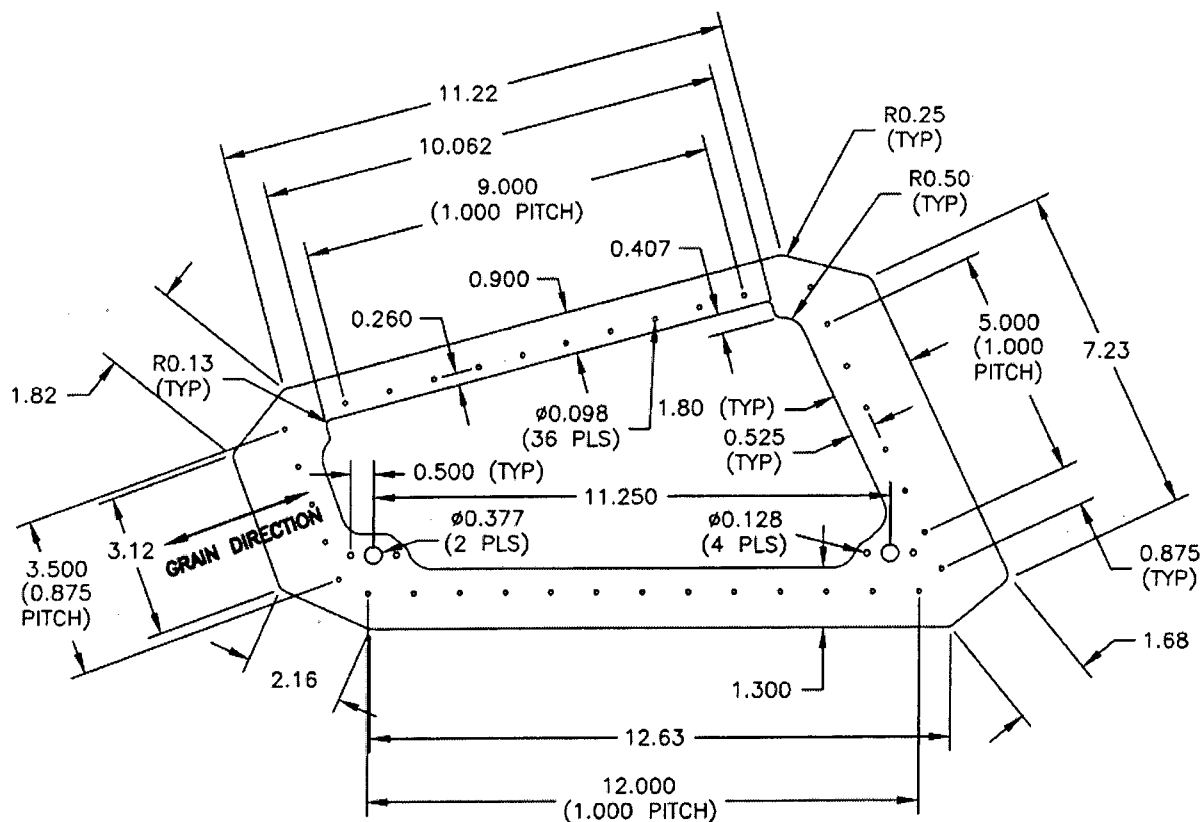
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04 04 14 *[Signature]*



**D3259-3/-4 DOUBLER FLAT PATTERN**  
( $\phi 0.098$  HOLES TO COINCIDE WITH HOLES IN D3259-1)





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NO. 34250

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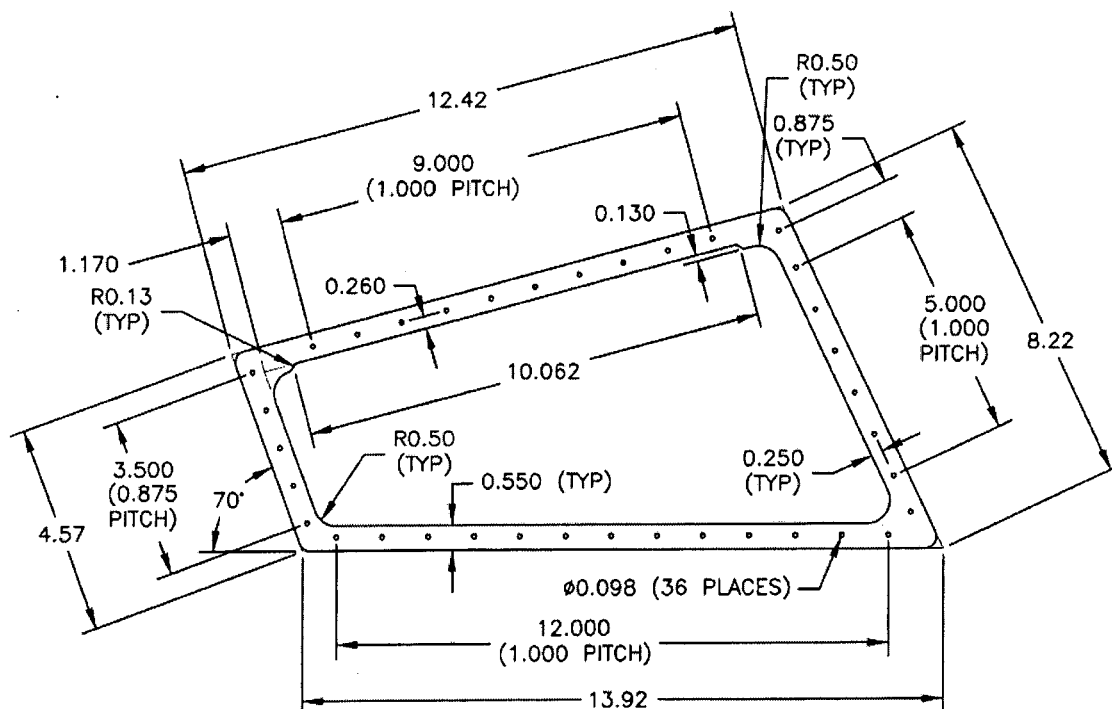
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04-04-05



**D3259-5 SPACER**

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"  
2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE INCHES  
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 34250

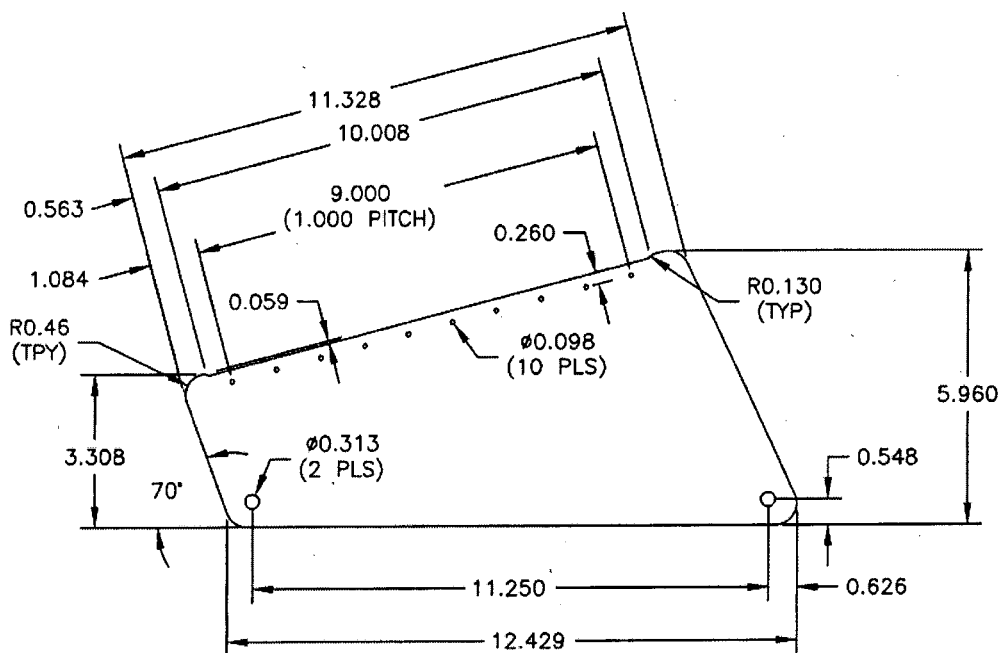
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.14 *[Signature]*



**D3259-7 DOOR**

**NOTES:**

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 34260
Description: PANAL		Part Number: D32591
Inspection Dwg: D32591 Rev: A1		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.188	+10.010	15.190	✓		M-T	
6.609	+10.010	6.600	✓		M-T/Vern	
17.125	+10.010	17.125	✓		M-T	
12.000	+10.010	12.000	✓		M-T	
1.000 (Pitch)	+10.010	1.001	✓		Vern	
11.113	+10.010	11.100	✓		M-T/Vern	
5.000	+10.010	5.000	✓		M-T	
1.000 (Pitch)	+10.010	1.001	✓		Vern	
9.000	+10.010	9.000	✓		M-T	
1.000 (Pitch)	+10.010	1.002	✓		Vern	
3.500	+10.010	<del>3.500</del> 3.503	✓		Vern	
0.875 (Pitch)	+10.010	0.883	✓		Vern	
0.260	+10.010	0.255	✓		Vern	
1.750	+10.010	1.745	✓		Vern	
0.098	+0.004 +0.001	0.101	✓		Vern	
2.150	+10.010	2.152	✓		Vern	

Measured by: DAD	Audited by: En	Prototype Approval: N/A
Date: 07/08/25	Date: 07/08/27	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	